

Del R. 1.000

Work Order ID 85864

\*85864\*

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June-18-12 10:50:15 AM

Item ID: D2054

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Bushing

Start Date: 15/06/2012 Start Qty: 20.00

\*20\*

Cust Item ID:

Required Date: 02/07/2012 Req'd Qty: 20.00

\*20\*

Customer:

Reference:

Approvals:

Process Plan: MLJ

Date: 12/06/18

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
<b>Draw Nbr</b>	<b>Revision Nbr</b>								
D2054	Rev B								
100		0.00							
<b>*100*</b>	Hardinge CNC LATHE SMALL								
Hardinge	<b>Memo</b>	0.00		<u>12/12/14</u>		<u>20</u>	<u>0</u>		
Hardinge CNC Lathe Small	Machine as per folio FA Deburr								
110		0.00							
<b>*110*</b>	QC2- Inspect parts off machine FAI/FAIB								
QC	<b>Memo</b>	0.00		<u>12/12/14</u>		<u>20</u>	<u>0</u>		
Quality Control									
120		0.00							
<b>*120*</b>	QC8- Inspect parts - second check								
QC	<b>Memo</b>	0.00		<u>12.12.15</u>		<u>20</u>	<u>4</u>		
Quality Control									

DAS  
04  
9-89

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**\*85864\***

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**Accept**

**\*N900040100\***

Setup Start \*NS1\*

Stop **\*NS2\***

**Start Date:** 15/06/2012    **Start Qty:** 20.00

\*20\*

**Cust Item ID:**

**Required Date:** 02/07/2012      **Req'd Qty:** 20.00

**\*20\***

**Customer:**

**Reference:**

**Approvals:**      **Process Plan:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Tooling:** \_\_\_\_\_ **Date:** \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop \*NR2\*

### Operation Description

### Set Up/ Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

130

Identify as per dwg & Stock Location:

0.00

**\*130\***

## Packaging

## Memo

0.00

## Packaging

140

QC21- Final Inspection - Work Order Release

0.00

**\*140\***

QC

## Memo

0.00

## Quality Control

20x \_\_\_\_\_ Sp  
12-12-17

12/12/18 ~~7~~

MCJ 12-72-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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**NOTE:** Date & initial all entries

# Picklist Print

June-18-12 10:50:19 AM

Page 1

Work Order ID: 85864

**\*85864\***

Parent Item: D2054

**\*D2054\***

Parent Item Name: Bushing

Start Date: 15/06/2012

Required Date: 02/07/2012

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP A1 03.01.21 Revise Dwg Rev B; added Black Teflon or Delring: Made on Cobra RF

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MDELRINR1.000		Purchased	No			120	f	23.3202	0.0583	1.227368			
<b>*MDFI RINR1 000*</b>									<b>**</b>	<b>1.333'</b>		<i>12/12/12</i>	
Delrin Round Bar 1"													

Location

Loc Qty

Loc Code

MAT055

23.3202

117985

0.407

118392

6.2762

119306

16.637

**122.582**

**1.333'**

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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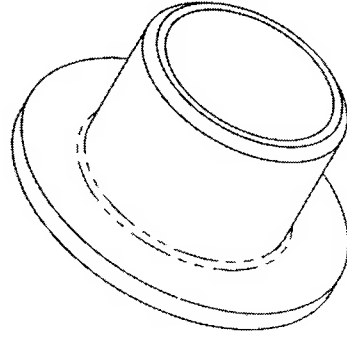
**NOTE:** Date & initial all entries





RELEASED  
01.12.21

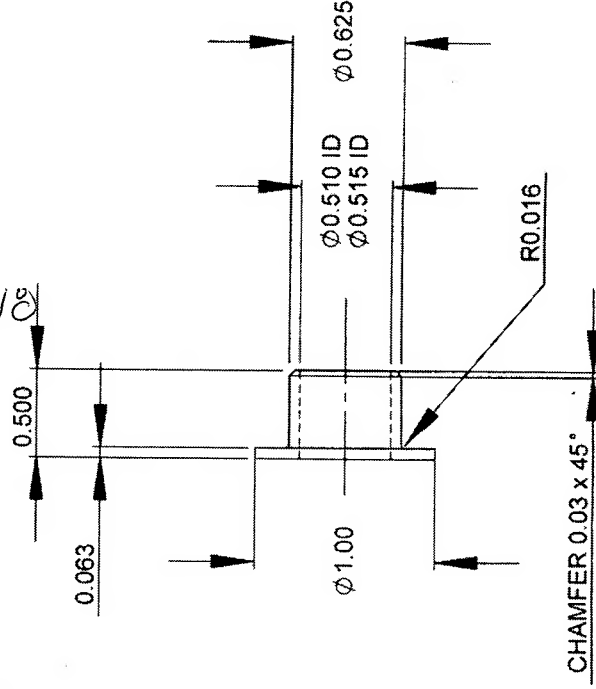
DESIGN	JB	DRAWN BY	LP	DART AEROSPACE LTD
CHECKED	[Signature]	APPROVED	[Signature]	HAWKESBURY, ONTARIO, CANADA
DATE	01.12.20	TITLE	BUSHING	REV. B SHEET 1 OF 1
--	92.05.13	NEW ISSUE		SCALE 1:1
A	01.06.05	CHANGE TOL. ON ID.		
B	01.12.20	REDRAW; ADD DELRIN OPTION; ADD NOTES		



ISOMETRIC DETAIL (SCALE 2:1)

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 88864 M/L5

12/06/18



**D2054 BUSHING**

MATERIAL: BLACK TEFLON  
or BLACK UHMW  
or BLACK DELRIN

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
ALL DIMENSIONS ARE IN INCHES

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